Work Ord September-23-1				*	1073	96*							Page 1
Item ID: Revision ID:	D4061-1		,	Accept	*	N9000	140	100)*	Setup	Start Stop	*N:	S1*
Item Name: Start Date: Required Date: Reference:	9/18/13 9/23/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*			Cust Item ID Customer:) :					"N:	S2*
Approvals:		n: MC5	Date: 13:09-24	Tooling:		Dat			1	Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center I	D	Operation Description		Set U Run	p/ Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr											
D4061	В												
*1 \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\	ng Machine	FOLIO REV DWG REV:	β	0.00	OAS 40 9-89	13/10/07			2c	2	Ø		
110		2-Deburr as QC2- Inspect parts off ma	•	0.00							` &		
110		Memo		0.00	DAS)	13/10/07	L		20	<u> </u>	Ø		

Memo

Quality Control

DQA:	Date:	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

									QA Closed:	Da	te:
Work Orde	er:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N	No				Rework Scrap Use-as-is Work Order Update		Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Quality Other
			T 1							r	
Root					iption of work order update	Initial	i	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	cription	Date	Verificatio	n QC Inspector
Doc/Data										1	
Equip/Tooling											
Operator	Ш										
Material											
Setup											
Other										}	
Process						1					
Supplier		İ								ĺ	
Training											
Unapproved										<u> </u>	
					F	AULT CATE	GORY				
Landi	ng Gear				General				_		
	Bendin	g			Bend	Grain			Ovalized		Pressure/Forced
	Centre	Not Conce	ntric to (D/S	BOM/Route	Hardw	are		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspect	tion Incomplete		Part Incorre	ct	Weld
	Crushe	d/Crimped			Burrs	Instruc	tions Incomplete,	/Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
	Cuffs				Contamination	Maint	enance		Part Moved		
	Heat T	eat			Countersink	Mislab	eled	[Positioned V	Vrong	
	Inspec	ion Strip ir	Tube		Cut Too Short	Misrea	d		Power Loss/	'Surge	Other
	Ripples	in Bend			Drill Holes	Offset					
	Torque	Waves in	Extrusion	,	Drawing	Out of	Calibration				
	Turning	g Sequence	<u>.</u>		Finish	Out of	Sequence				
	Maye/	Twist in Tu	he		Folio	Outsid	a Dimensions				

Work Order ID 107396 September-23-13 11:49:57 AM				Page 2									
Item ID: Revision ID: Item Name:	D4061-1 Ski Cushion			Accept	*	1 900	040	100	ገ*	Setup	Start Stop	ı VI -	S1* S2*
Start Date: Required Date: Reference:	9/18/13 9/23/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*			Cust Item II Customer:	D:						
Approvals:	Process Pla	in:	Date:	Tooling: SPC (Y/N):		Da	te:			Run	Start Stop	171	R1* R2*
Sequence ID/ Work Center II 120 *120* QC Quality Control	D	Operation Description QC8- Inspect parts - seco	nd check	Set Up/ Run Hours 0.00	b.a	Tool ID	Tool#	Plan Code	Accept Qty	Qt		Reject Number	Insp. Stamp OAS 08 9-89
*130 *130* Packaging Packaging		Identify as per dwg & Sto	ock Location STY	0.00					<i>2</i> 0.1			13	DAS 26 9-89
140 *140* QC		QC21- Final Inspection -	Work Order Release	0.00		·				[]	m 13	3/10/0°	8 ;

Quality Control

												DQA:	Da	te:	
NCR:	⁄es	/ No				WORK ORDER NON-C	100	NFORM	MANCE / UPI	DATE		QA Closed:	Da	to:	
					, - , - ,	T				-		QA Closed.	Da	te.	· · · · · · · · · · · · · · · · · · ·
Work Orde	er:					DISPOSITION				AGAINST D	Œ	PARTMENT	PROCESS		
	•				· · · · · · · · · · · · · · · · · · ·	Rework	1		Skid-tube	Crosstube	\neg	1	Water Jet		Engineering
Part N	۱o.					Scrap Machining			Machining	Small Fab		Pro	d. Eng. Coor.		Quality
	-					Use-as-is]	Thern	noforming	Finishing		Rec/Stor	e/Packaging		Other
NCR N	١o.					Work Order Update]		Large Fab	Composite			Supplier		
Root	T		<u> </u>		Descri	ption of work order update		Initial	Act	tion	_	Sign &	11 8 101 111		
Cause		Date	Step	Qty		or Non-conformance	1	ief Eng		ription		Date	Verificatio	n	QC Inspector
Doc/Data		-													·
Equip/Tooling															
Operator											ı				
Material											ı				
Setup	 Li		Ì								ı				
Other .											į		ı		
Process											1				
Supplier				,											
Training											1				
Unapproved															
	*					F	AUL	T CATE	GORY		_				
Landi	ng G	Gear			_	General				_		-			,
		Bending				Bend		Grain				Ovalized			Pressure/Forced
		Centre No	ot Conce	ntric to	O/S	BOM/Route		Hardwa	re	L		Over/Under	tolerance	$ldsymbol{ldsymbol{ldsymbol{eta}}}$	Temperature/Cure
	Н	Cracks				Broken/Damaged	$ldsymbol{ld}}}}}}$	4 '	on Incomplete	L		Part Incorred			Weld
	-	Crushed/	Crimped			Burrs		4	ions Incomplete/l	Jnclear		Part Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs			-	Contamination		Mainte	nance		ı	Part Moved			

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

September-23-13 11:49:57 AM

Work Order ID:

107396

Parent Item:

D4061-1

Parent Item Name:

Ski Cushion

Start Date: 9/18/13

Required Date: 9/23/13

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP REV:A NEW ISSUE JLM 10-02-18 VERIFIED BY:EC

IPP REV:B 11.01.10 AS PER

DWG REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4287-3		Manufactured	No			100	f	18.4000	0.4125	8.684210	2.A.C	12/1	/
Uhmw U-Channel							•				70	13/10	10+
				Location		Loc Qty	<u>Lo</u>	c Code			40 9-8 ⁹		
				ST202		6.4							
				91102		6.4							
				ST209a		12							
				97824		12							
				n (c)75	カユ				1.0	0.0			

•	•		
DQA:		Date:	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

		_								QA Closed	. Dat	te:
Work Orde	, ,.				DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Part N					Rework Scrap Use-as-is	- - - - -	ſ	Skid-tube Machining	Crosstube Small Fab Finishing		Water Jet od. Eng. Coor. re/Packaging	Quality
NCR N	lo	. i 			Work Order Update]		Large Fab	Composite		Supplier	
Root		<u> </u>		Descri	ption of work order update	In	itial	Ac	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chie	ef Eng	Desc	cription	Date	Verification	n QC Inspector
Doc/Data Equip/Tooling Operator Material												
Setup	7									1		
Other												
Process											•	
Supplier												
Training							ļ	i				
Unapproved												
					F	AULT	CATE	GORY				
Landin	ng Gear				General						_	
	Bending				Bend		Grain			Ovalized		Pressure/Forced
į	Centre No	ot Concer	ntric to (D/S	BOM/Route	}	Hardwa	re		Over/Under	tolerance	Temperature/Cure
Ĺ	Cracks				Broken/Damaged		nspecti	ion Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped			Burrs		nstruct	ions Incomplete/	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	enance	L	Part Moved		
. [Heat Trea	at			Countersink		Mislabe	eled	L	Positioned \	N rong	
[Inspectio	n Strip in	Tube		Cut Too Short		Misreac	t	Ĺ	Power Loss,	/Surge	Other
	Ripples in	n Bend			Drill Holes		Offset					
	Torque W	Vaves in E	extrusion	٦	Drawing		Out of (Calibration				·
	Turning S	equence			Finish	\square	Out of S	Sequence				
	Wave/Tw	ist in Tub	oe .		Folio	\Box	Dutside	Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

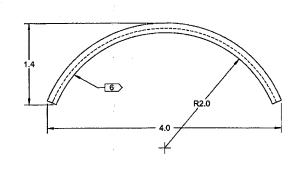
DART AEROSPACE LTD	Work Order:	107396
Description: Ski Cushion	Part Number:	D4061-1
Inspection Dwg: D4061 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.95	+/-0.030	4.953			Voru	P-10-12
0.17	+/-0.030	, 175	V		"1	17
1.050	+/-0.010	1,049	V		16	, ,
0.10	+/-0.030	.100	V			, .
0.076	+0.015/-0.000	2085			1,	1(
1.25	+/-0.030	1,256	/		•	- 1
•			, ,			
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			·			
		-				
	CAQ.					

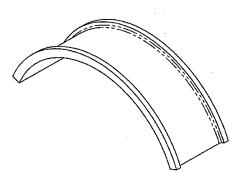
Measured by: 40	Audited by: B.A. OR	Preliminary Approval:
Date: 13/10/07	Date: (3)10)07 ×89	Date:

Rev	Date	Change	Revised by	Δ	Approved
Α	11.02.11	New Issue	KJ 9	X	&



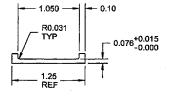
<u>D4061-1 412 SKI CUSHION</u>
(MAKE FROM D4061-1F)

107396 MLJ 13-09-24



0.17 -

№ D4061-1F FLAT MACHINED STATE



DELEASE 2010 -12- 23 20

В	CHANGED RAW MATERIAL TO REDUCE MANUFACTURING COSTS; PART NOW MACHINED FLAT AND SHAPED WITH ADEQUATE RADIUS. REF: PART0-29.					10.12.07
Α	NEW ISSUE				МВ	10.03.31
REV.			DESC	DESCRIPTION BY		DATE
DESIGN		13		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN		J.				
CHECKED		Sc		DRAWING NO. D4061		REV. B
MFG. APPR.		Ro	\ \ \ D4			SHEET 1 OF 1
APPROVED /		Med	m	TITLE 412 SKI CUSHION		SCALE
DE APPR.		-#	41			NTS
DATE 10.12.07				COPYRIGHT © 2010 BY DART AEROSPACE LTD THE DOCUMENT SPRINTE NO CONFEDERAL HIS IS SUPPLIED ON THE EXPRESS CEREMENT THAT IT IS NOT TO BE USED FOR MY PROPOSE OR COMPANY OR TO THE PERSON WITHOUT		

NOTES:
1) MATERIAL: MAKE FROM D4287-3 B
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4061-1" AND B/N "BXXXXX" PER QSI 044 6.1
7) WEIGHT: 0.02 lbs

D